

Date: Friday, 14/11/2008 10:21:01 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B LOW GEAR WEB		
Job Number	: 43445		Part Number	: D26541		
Estimate Number	: 11768		Drawing Number	: D2654 REVE1		
P.O. Number	:		Project Number	: N/A		
This Issue	14/11/2008	S.O. No.	Drawing Revision	: E1		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type	Due Date	28/11/2008	Qty:	1
Previous Run	: 41267		Um:	Each		
Written By	:					
Checked & Approved By	: JLD 08.11.14					
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web 38582		
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1		

1-Cut D2600-5 to length as per Dwg D2654 (73.85")

2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005.4.1		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: 206 A/B LOW GEAR WEB

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-11-18

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 6b

8-11-18

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/21 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6/28/11 27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

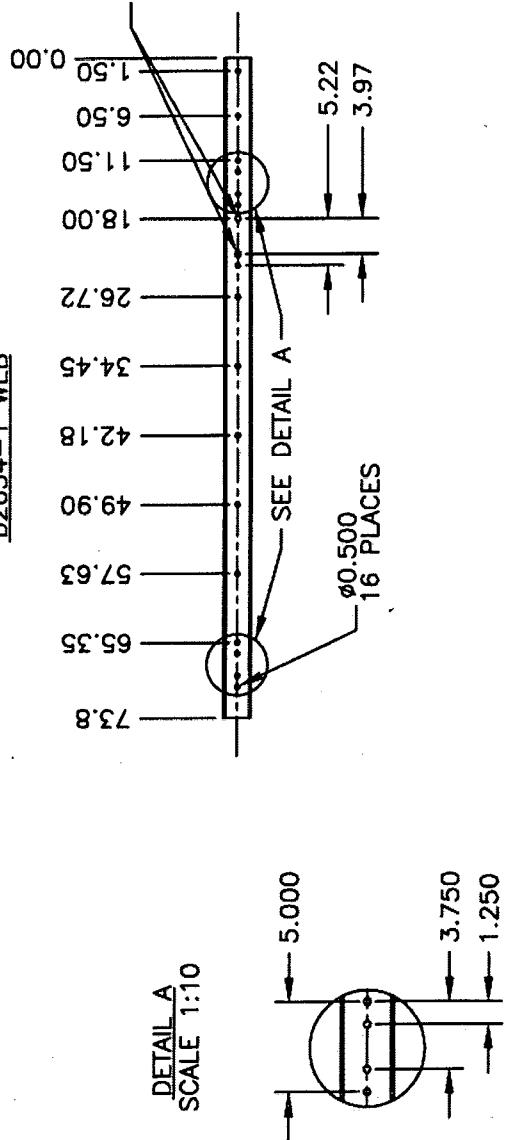
NOTE: Date & initial all entries

DARTCOPY
SERIAL
NUMBER

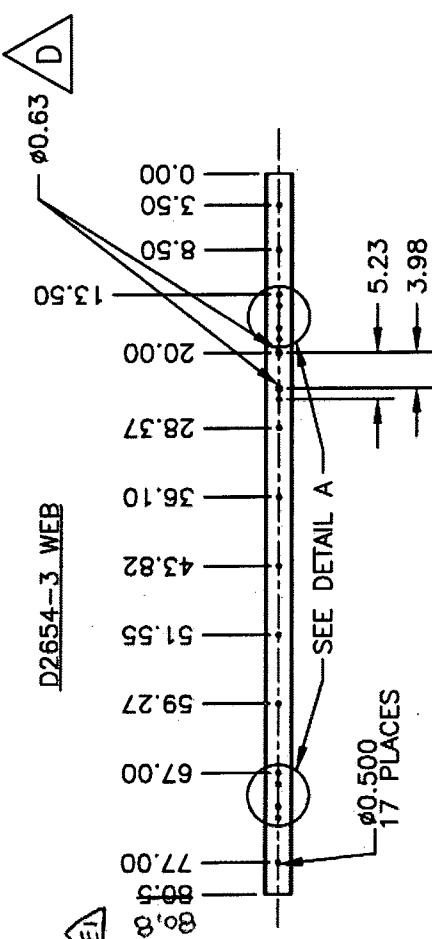
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



SHOP CO
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. 13445

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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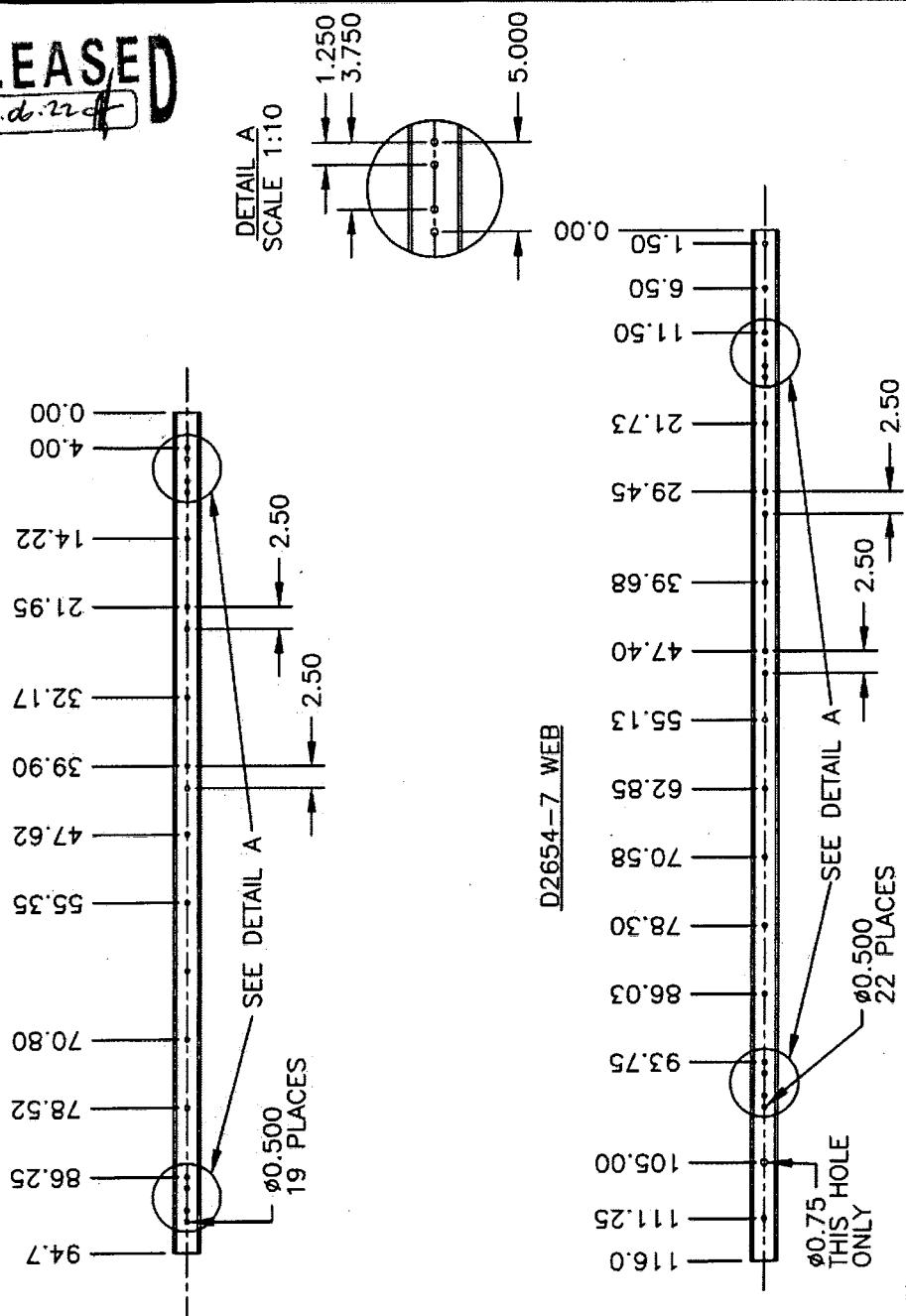


A circular stamp with the words "A COPY ISSUED" arranged in a circle, with a small "1" in the center.

DESIGN <i>IP</i>	DRAWN BY <i>IP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>IP</i>	APPROVED <i>IP</i>	DRAWING NO. D2654	REV. E	SHEET 2 OF 2
DATE 04.05.26	TITLE WEB		SCALE 1:20	

RELEASER
04.08.2014

D2654-5 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 43445

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